

Work Order ID 80083

80083

Page 1

February-09-12 4:27:31 PM

Item ID: D2739

Revision ID:

Item Name: 350 I Beam

Start Date: 09/02/2012 Start Qty: 4.00

Required Date: 23/02/2012 Req'd Qty: 4.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: M.C.S

Date: 12/02/09 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2739	Rev E								
100	Skid tubes	0.00							
100									
Skid tubes									
Skid tubes	Memo	0.00							
	1-Cut D2600-5 to length as per Dwg D2739.								
	2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739.								
	3-Use uni-bit to open holes to finish size as per Dwg D2739.								
	4-Bevel Fwd end of extrusion and Deburr holes and ends.								
	5-Deburr								
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
Hand Finish	Memo	0.00							
Hand Finishing									

NOT FOR INFORMATION

Dart Aerospace Ltd

W/O: 80083		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2739 PAR #: Fault Category: landing gear NCR: Yes No DQA: Date: 12/03
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: MJS Date: 12/03 ⁰⁵

NCR: 2		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-3-1	100	Found 1 D2600-5-108 Damaged in inventory. B# 33909 RC, shipping, not found while stacking	S 2634 051012	Scrap & replace w/ 1373907 Qty 1 D2600-5-108	OK 12-3-1	NO 12-3-1	S 2634 051012	S 127034

NOTE: Date & initial all entries

W/O: 80083		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2739 PAR #: Fault Category: landing gear NCR: Yes No DQA: Date: 12/03/05
12-1772 Resolution: Scrap Disposition: Scrap QA: N/C Closed: MLJ Date: 12/03/05

NCR: <u>12-1772</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>10.94</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>12-3-1</u>	<u>100</u>	<u>Found 1 D2600-5-108</u> <u>Damaged in inventory.</u> <u>B# 33909</u> <u>RC, shipping, not found while</u> <u>stocking</u>	<u>S</u> <u>2/24/05</u> <u>Q11012</u>	<u>Scrap & replace</u> <u>w/ B73907 QTY 1</u> <u>D2600-5-108</u>	<u>OK</u> <u>12-3-1</u>	<u>NO</u> <u>12-3-1</u>	<u>S</u> <u>2/24/05</u> <u>Q11012</u>	<u>S</u> <u>12/03/05</u>

NOTE: Date & initial all entries

Work Order ID 80083***80083***

Page 2

February-09-12 4:27:31 PM

Item ID: D2739 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 350 I Beam
Start Date: 09/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 23/02/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130						10	Ø	BE 12-03-05	
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: LG	0.00							
140						10	Ø	BE 12-03-05	
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150						MLJ		12/03/05	
QC	Memo	0.00							
Quality Control									

12-03-05
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-09-12 4:27:35 PM

Page 1
7

Work Order ID: 80083

80083

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	227.0000	1	4			

D2600-5-108

Extrusion 'I Beam' thin

**

CF 12-2-29

Location

LG

47814

73909

Loc Qty

227

20

207

Loc Code

~~11~~ 11 12-3-1
CF

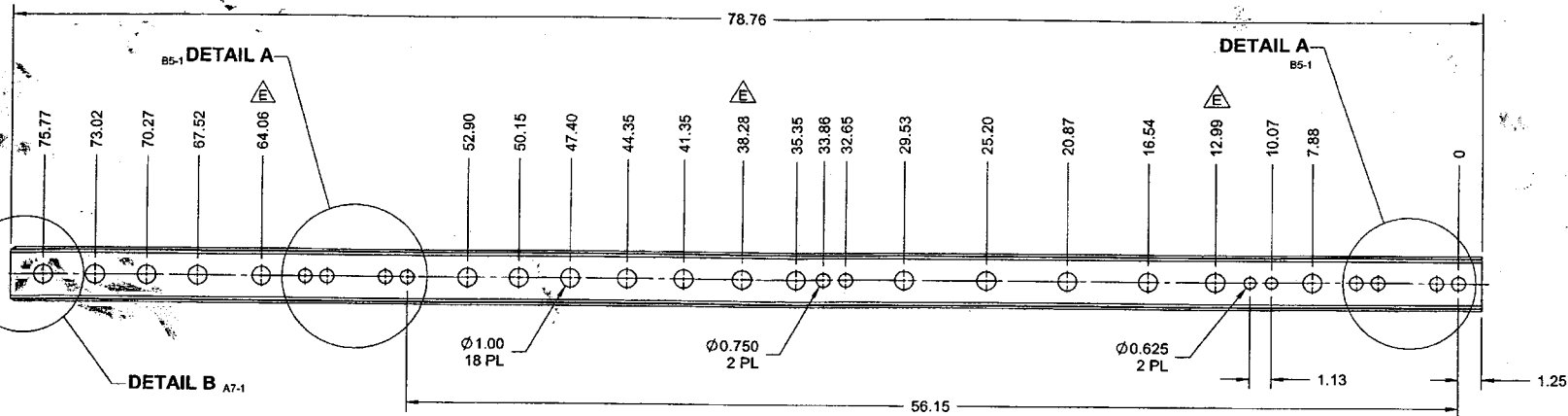
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

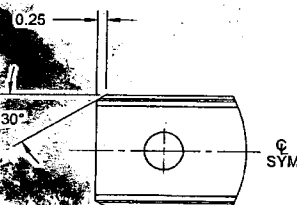
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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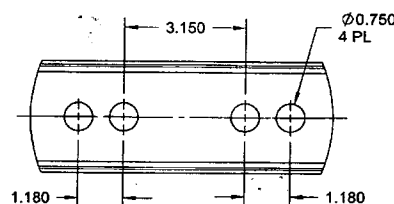
NOTE: Date & initial all entries



D2739 WEB



DETAIL B
SCALE 3X
C7-1



DETAIL A
SCALE 3X
D7-1, D2-1

RELEASED
2010-11-01

800-83-MCJ
12/02/09

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
 - 7) WEIGHT: 3.41 lbs

E	ADD/MOVE HOLES FOR D4154 WEARPLATE. 38.28 WAS 38.35 (D5-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D2739	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	10.10.08	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
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